

Work Order ID 59999

June 22, 2010 2:32:21 PM

ASAP !!



Page 1

Item ID: D4051-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rappel Deflector Assembly, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *✓*

Date: *10-6-27*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4051

a

100

Weld per dwg A/R S.S. rod Batch *50100875* 0.00



Large Fab

Memo

0.00

Large Fab

1- Weld brackets, filler and mounting plate to bar using basket

AD 10.07.06

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 10.07.06

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S weld 10/6

*test Fit on Basket
OK 5/6/06*

(C)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59999

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Page 2

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M114841

0.00

Powder Coating

Memo

POWDER COAT:

Start Time: 11:55

Oven Temperature: 400°

Finish Time: 12:25

① BR 10-7-6..

140

0.00



HandFinish

Memo

0.00

Hand Finishing

Install label as per dwg

SB 1067106

①

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sublot
SB 1067106

①

W/O:		WORK ORDER CHANGES					
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Work Order ID 59999

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Page 3

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Item Name: Rappel Deflector Assembly, LH

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Start Date: 6/22/10 Start Qty: 1.00



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Required Date: 6/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sublot

40

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Call 10/7/6 @

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF 10-7-6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:32:20 PM

Page 1

Work Order ID: 59999

Parent Item: D4051-041

Parent Item Name: Rappel Deflector Assembly, LH






Start Date: 6/22/10

Required Date: 6/29/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.14 verified by:EC IPP Rev:B as per
dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4051-1  Rappel Deflector		Manufactured	No			100	Each	0.0000	1	1			
D4051-3  Bracket		Manufactured	No			100	Each	1.0000	2	2			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			1			560223 →			
					56110		1						
D4051-5  Mounting Plate		Manufactured	No			100	Each	1.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			1						
					55995		1			①			
D4051-7  Filler		Manufactured	No			100	Each	3.0000	1	1			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			3						
					55997		3						
D4051-9  Placard		Manufactured	No			140	Each	4.0000	3	3			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST111			4						
					55272		4						
										3		SB 12/07/10	①

B59998 → ① PD 10.07.01

B60223 → ② PD 10.07.06

PD 10.07.06

B60280 → ① PD 10.07.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

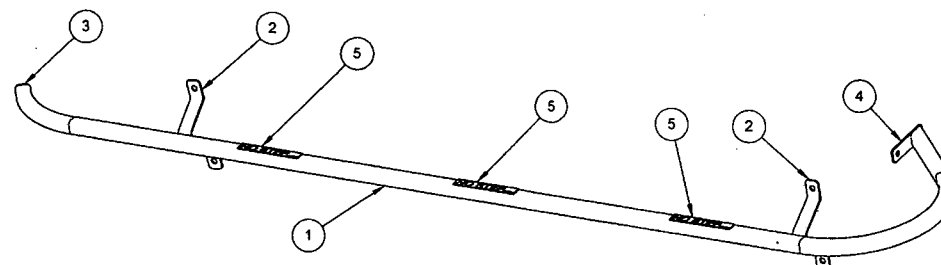
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D4051-041	RAPPEL DEFLECTOR ASSY
		X	D4051-042	RAPPEL DEFLECTOR ASSY
1	1	1	D4051-1	RAPPEL DEFLECTOR
2	2	2	D4051-3	BRACKET
3	1	1	D4051-7	FILLER
4	1	1	D4051-5	MOUNTING PLATE
5	3	3	D4051-9	PLACARD



D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN)
D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDM.
WITHOUT NOTICE
WORK ORDER
NO. 59999

PS10-6-22

RELEASED
2010-02-16
JMP

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4051	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	RAPPEL DEFLECTOR ASSY	NTS
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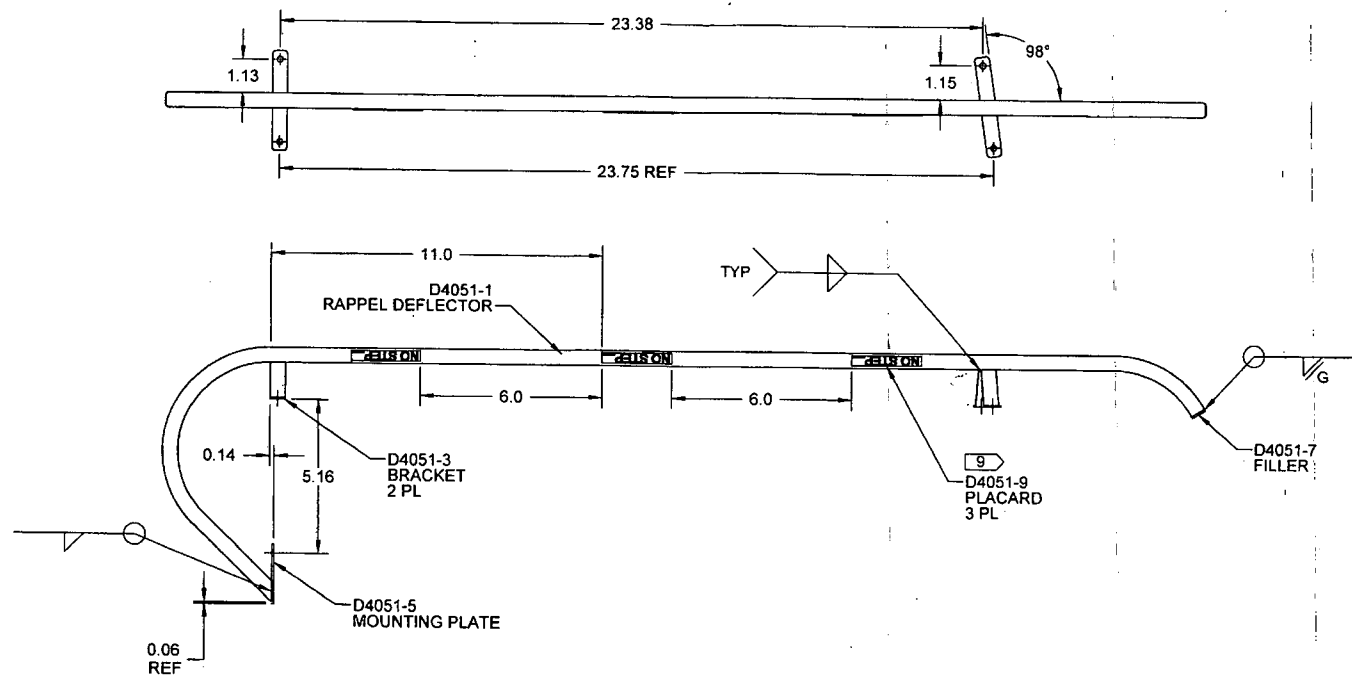
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4051-041 RAPPEL DEFLECTOR ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.07 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

RELEASED
2010-02-16
MP

w/c 59299

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4051	SHEET 2 OF 7
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	RAPPEL DEFLECTOR ASSY	
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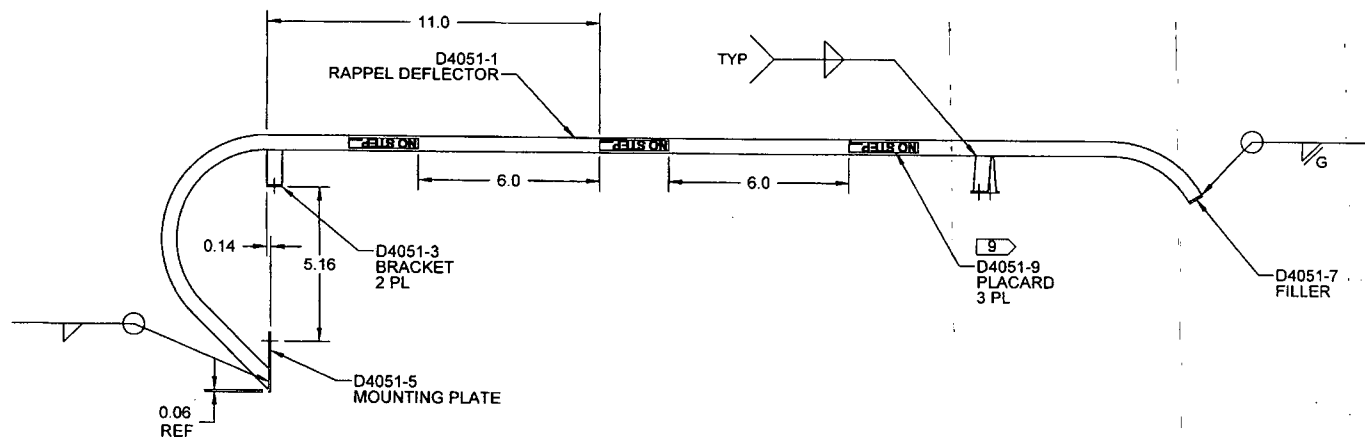
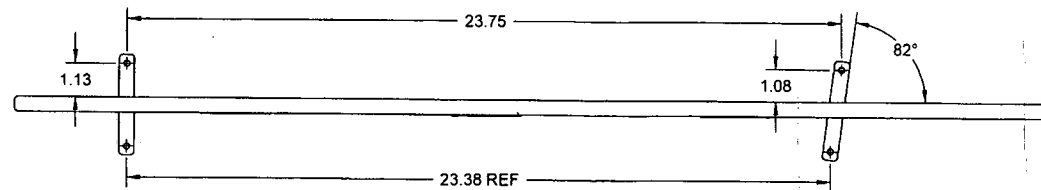
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4051-042 CABLE DEFLECTOR ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.07 lbs
- 8) WELD PER DART QSI 004
- 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	18	D4051	SHEET 3 OF 7
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2010-03-16

W1039929

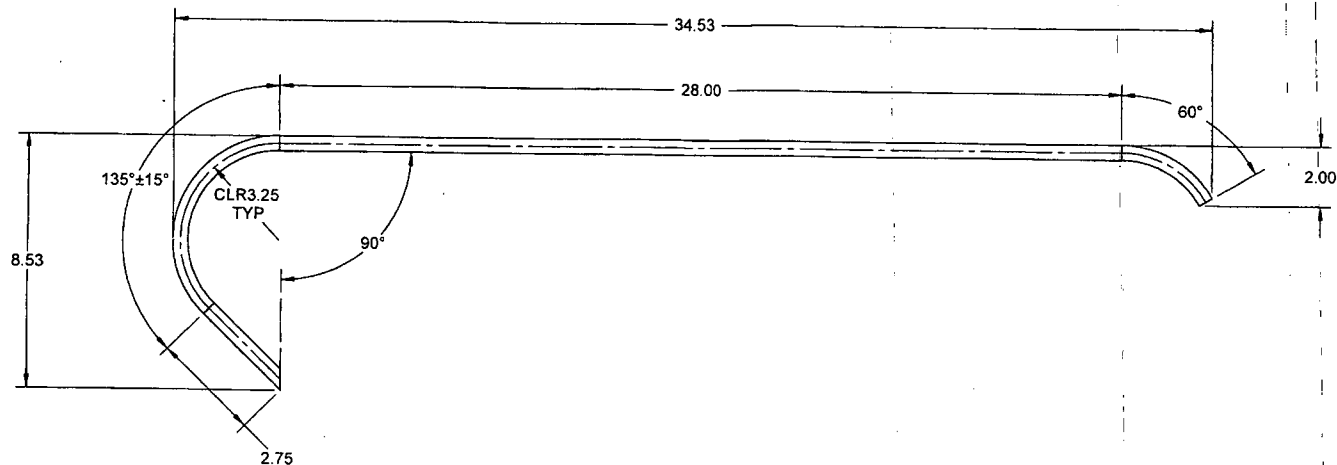
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 D4051-1 RAPPEL DEFLECTOR

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.98 lbs
- 8) TUBE FLAT LENGTH 43.00 REF

RELEASED
2010-02-16

WLO 59999

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4051	SHEET 4 OF 7
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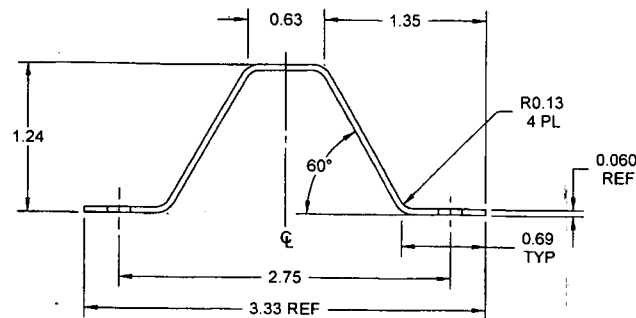
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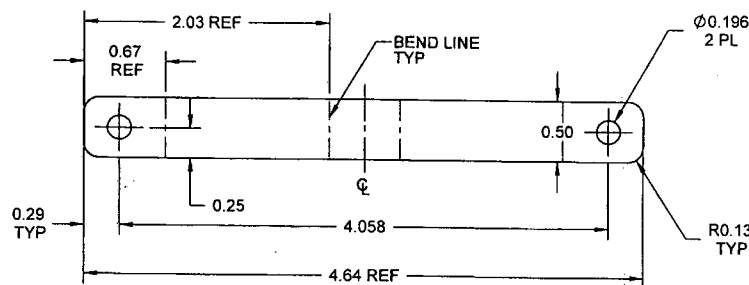
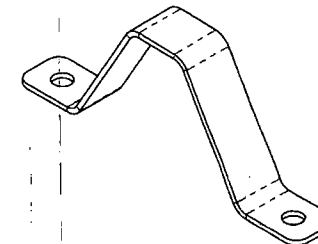
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NOTE: Date & initial all entries



D4051-3 BRACKET
(MAKE FROM D4051-3F FLAT PATTERN)



D4051-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

RELEASED
2010-02-16
WIP

WLO 59999

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4051	REV. A
MFG. APPR.	RF	TITLE	SCALE
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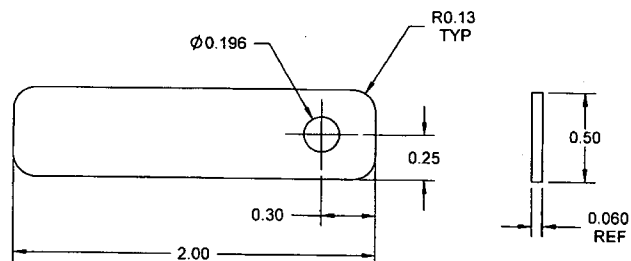
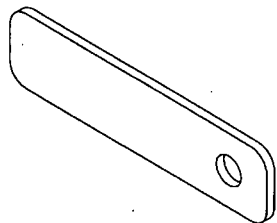
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

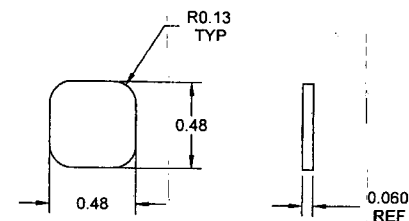
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NOTE: Date & initial all entries



D4051-5 MOUNTING PLATE



D4051-7 FILLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4051-5: 0.02 lbs
D4051-7: 0.004 lbs

RELEASED
2010-02-16
MP

WLB 5999.9

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4051	REV. A
MFG. APPR.	RF	SHEET 6 OF 7	
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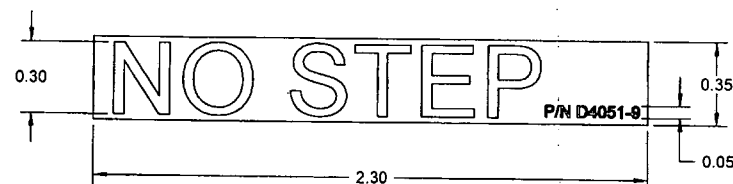
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NOTE: Date & initial all entries



D4051-9 PLACARD

NOTES:

- 1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2010-02-16
AND

W/0 39999

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4051	REV. A
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	RAPPEL DEFLECTOR ASSY	NTS
DE APPR.	RF	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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